

Date: * Wednesday, 13/08/2008 10:55:33 AM
 *User: Julie Lecocq

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: TUBE ARM
Job Number	: 41215		
Estimate Number	: 13518		
P.O. Number	:	Part Number	: PB674300187
This Issue	: 13/08/2008 S.O. No. :	Drawing Number	: B6743001 P.30
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: / / Type : SMALL /MED FAB	Drawing Revision	: B1
Previous Run	:	Material	:
Written By	:	Due Date	: 15/09/2008
Checked & Approved By	: <u>MD 08.8.13</u>	Qty:	<u>5</u> Um: Each
Comment	: Est Rev:A 08-06-26 new issue DD verified by:ec		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M6061T6T1000W065	6061T6 RD TUBE 1.00 x .065w
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Comment: Qty.: 5.0308 f(s)/Unit Total: 30.1846 f(s)

6061 TUBE

batch: M108961

SAD

08/09/27

5

2.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1

1- cut to length as per dwg

SAD 08/09/24 (5)

2- drill holes as per dwg (DO NOT DRILL THRU)

3- make a radius cut out at one end of tube as per dwg

SAD 08/09/24 5

4- deburr

08.09.25 5

3.0	QC5	INSPECT WORK TO CURRENT STEP
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Comment: INSPECT WORK TO CURRENT STEP

S 08/09/26 25

4.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: corner corner

8/9/26

(5)

SAD

5.0	QC21	FINAL INSPECTION/W/O RELEASE
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Comment: FINAL INSPECTION/W/O RELEASE

08/09/30 25

Job Completion



mf 08-09-26

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

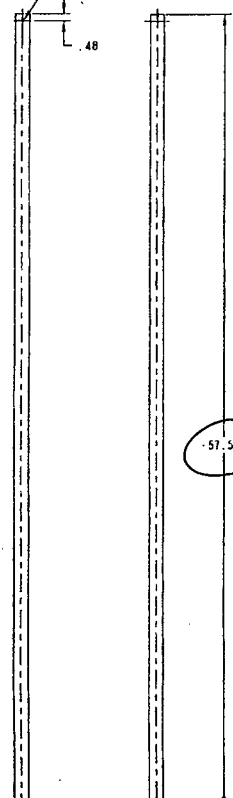
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

RELEASED
17 DEC 91 20

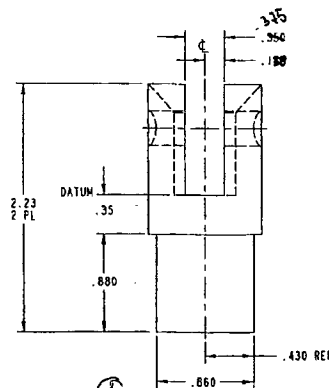
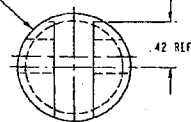
NO. 60 (Ø .040) PILOT HOLE



① -87 TUBE ARM

MATL: 1.00 OD X .065 WALL, 6061-T6, WW-T-700/6
SCALE 0.250

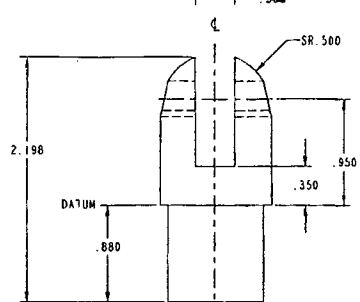
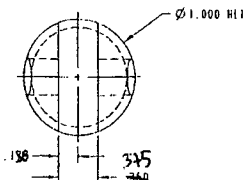
Ø 1.00 REF



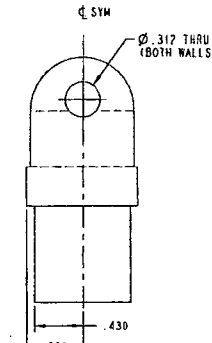
① JLM

-89 CLEVIS

MATL: 1.00 RND, 6061-T6, OO-A-200/8
SCALE 2.000



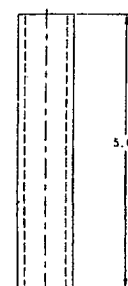
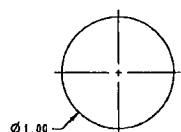
-97 CLEVIS (SHOWN)
MATL: 1.00 RND, 6061-T6, OO-A-225/8
SCALE 2.000



① JLM

② -93 TUBE END CAP

MATL: .063 THK, 6061-T6, OO-A-250/11
SCALE 2.000



① -91 TUBE HANDLE

MATL: 1.00 OD X .125 WALL, 6061-T6, OO-A-200/8
SCALE 1.000

PREMIER AVIATION, INC.

2001 Aviation Parkway, Grand Prairie, Texas 75050
D05UV8 B67-43001

ORIGINAL

NO. 47215
WORK ORDER
WITHOUT NOTICE
SUBJECT TO AMENDMENT
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ENGINEERING
RETURN TO
SHOP COPY

